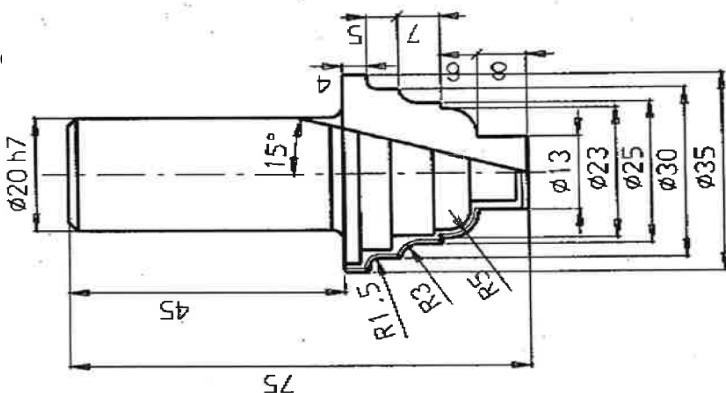


ShearAngle Profile Tool Ø35 Z2

A16-200

Facegrinding according to bottom angle of 15° and 2° Shearangle. Roughing is done in plunge grinding. The profile being open, pregrinding and finishing can be ground with standard cup wheels.

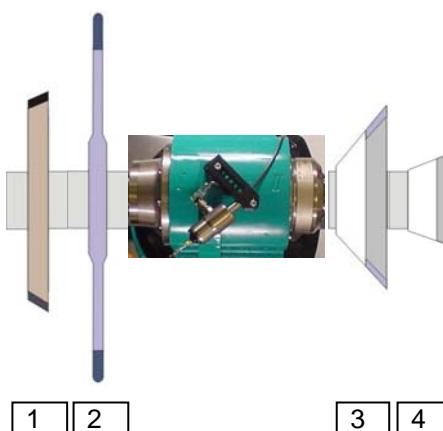


Workpiece:	D 35 mm, Z 2, Length 30 mm, ShearAngle 2° Material CARBIDE				
Operations	Probe	Flute 1	Prf Rough	Prf Pgnd	Prf fin
Feed [mm/Min]	2000	70	100	70	100
Power [kW]		3	2	1	1
Cutting feed [m/s]		22	20	22	22
Used wheels		1	2	3	4
Grinding time [s]	30	74	420	93	68
Total cycle time	11 Min 24				

The cycle times are indicative. Material to be ground, grinding wheels, coolants can influence the cycle times considerably.

2. Used Grinding Wheels

1	1V1 Ø125 D64
2	14F1 Ø200 D76R1.5
3	12V9 Ø150 D64
4	11V9 Ø100 D64



3. Machine and Software Requirements

Machines: 5 axes CNC grinders : NORMA CFG

Coolant: Synthetic Oil, pressure 6 bar

Control: Fanuc 310i

Software: Quinto 5

Accessories:

Responsible engineer: OP. 3.8.10

www.schneeberger.ch

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